Blue

Work Order ID 55774

February 1, 2010 10:18:49 AM

Item ID: D2724-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 206L Step Assembly

Start Date: 1/29/10 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 2/08/10 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-2-01 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2724	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Large Fab	0.00							
Large Fab		0.00							
Large Fab	**Memo**								
	Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding					4	4	PB-7	
						M 10.02.04			
110	Large Fab	0.00							
Large Fab		0.00							
Large Fab	**Memo**								
	Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898 followed by Jig A/R AL ROD Batch: M110130					4			
	Grind end cap welds flush					M 10.02.08			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D2724-042 **PAR #:** _____ **Fault Category:** Large Fab **NCR:** (Yes) No **DQA:** _____ **Date:** 10.03.04

Resolution: Scrap **Disposition:** Scrap **QA: N/C Closed:** _____ **Date:** 10/03/04

NCR: 55774		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
10/02/08	# 100	After the lugs + EndCap was welded on it was Found ~~that~~ that it was cut 1" too short.	[signature]	Qty +1 Scrap + Destroy + Replace M B 52026	[signature] 10.02.08	[signature] 10/02/08	[signature]	[signature] 10/02/08
		R.C. Lack of Attent Pins & welding						[signature] 10/02/08

NOTE: Date & initial all entries

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00				RD 10.02.09	(4)		
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00 ⇒ Sidel WO							
QC	**Memo**	0.00				x4RH			
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				4			
Hand Finishing									

10.02.10

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 55774

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Item ID: D2724-042 **Accept** **Setup Start**

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Required Date: 2/08/10 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control	=7m 10/02/10 (4X)								
160		0.00				4			
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
	Inspect for foreign object per QSI 024								
	Weld Remainig end cap as per Dwg D2724 using Jig DT8898 followed by Jig DT A/R AL ROD Batch: m110130 10.02.11								
	Grind end plate flush.								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Run Start **Stop**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00				PD 10021		9	
QC	**Memo**	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00 Solo2/14				84 RH			
QC	**Memo**	0.00							
Quality Control									
190	Chemical Conversion Coat per QSI005 4.1	0.00 BK 10-02-17.				HRH			
HandFinish	**Memo**	0.00							
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205 SprayPaint Spray Painting	Spray Painting per QSI005 4.2	0.00							
	Memo Prime Delfleet Blue B 110918 Paint Delfleet Blue B 113171 Clear Delfleet B 113314	0.00				10	02	22	(4)
215 QC Quality Control	QC14- Inspect Spray Paint	0.00							
	Memo	0.00							
220 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 113462	0.00							
	Memo	0.00							

10-02-23 (x4)

BL 10-02-24 (2) RA

230 QC 3

10.02.24

10-02-24

(4 x RA) O

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo** PM 55798	0.00					10/3/-1		(Y)
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							10/03/02
Quality Control									MF 10-3-1

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

February 1, 2010 10:21:14 AM

Work Order ID: 55774

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 1/29/10 **Required Date:** 2/08/10

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2734		Manufactured	No			120	Each	79.0000	8.0000		10.02.08	
Step End Plate												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	9		
43535	2		
48110	7		5
Main Warehouse			
WA	70		
55014	70		3

D3458-1		Manufactured	No			120	Each	51.0000	8.0000		10.02.08	
Step Mounting Plate												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	51		
51239	3		
53408	48		9

D3458-3		Manufactured	No			120	Each	45.0000	8.0000		10.02.08	
Step Mounting Plate												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	45		
53409	45		9

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

February 1, 2010 10:21:14 AM

Work Order ID: 55774

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 1/29/10 **Required Date:** 2/08/10

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	48.7400	4.0000		10·02·05	
Step Extrusion												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	48.74	
48612	3.12	
52026	45.62	

5

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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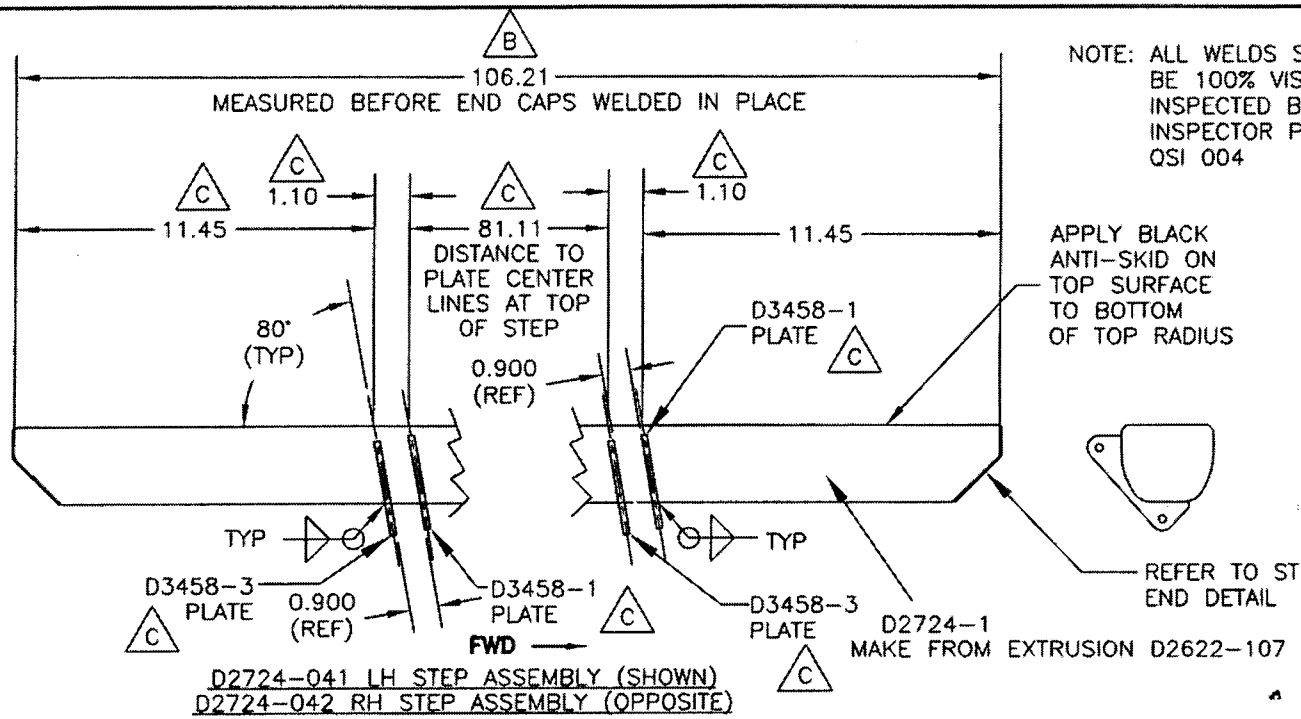
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



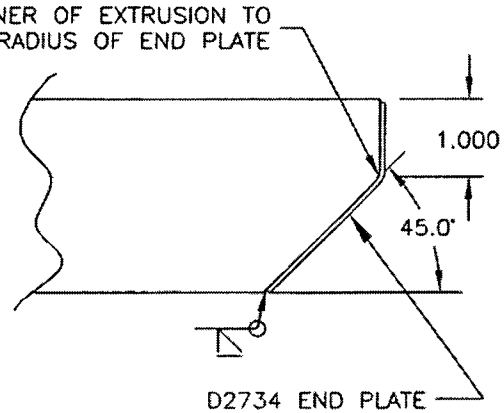
D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

RELEASED 05.11.19

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 55274
BY 10-2-01

D2724-041/-042 STEP ASSEMBLY

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.09.19	RE-DESIGN, ADD D3458-1/-3
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
A	97.12.04	NEW ISSUE

DESIGN: KE | DRAWN BY: PH | CHECKED | APPROVED

DATE: 05.09.19

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D2724 REV. C

TITLE: 206L/407 STEP ASSEMBLY

SCALE: NTS SHEET 1 OF 1